

Work Order ID 68361

Tuesday, April 12, 2011 10:12:05 AM



Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

*AP*Date: *4-04-12*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4154

A100 B 3 u.c. 12

100

0.00



Large Fab

Memo

0.00

Large Fab

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

2059 B Hardcoat Welding Rod

BATCH#: *M117659*

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH#: *M107051*

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

EL/K 11-6-12 (X5)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

CPH-06-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D4154-041

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Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 4/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



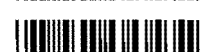
QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Small Fab	Memo	0.00				<u>W</u>	<u>11</u>	<u>06</u>	<u>06</u> (5)
Small Fab	1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154. M116210	0.00							
160 QC	QC5- Inspect part completeness to step on W/O	0.00				<u>(B)</u>			
Quality Control	Memo	0.00							
170 Packaging	Identify as per dwg & Stock Location: <u>FP-9</u>	0.00				<u>X5</u>	<u>d</u>	<u>11</u>	<u>116210</u>
Packaging	Memo	0.00							

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68361

Page 4

Tuesday, April 12, 2011 10:12:05 AM

Item ID:	D4154-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearplate Assembly					
Start Date:	4/12/2011	Start Qty:	6.00		Cust Item ID:	
Required Date:	4/15/2011	Req'd Qty:	6.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/6/9 JF.

MF
11-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

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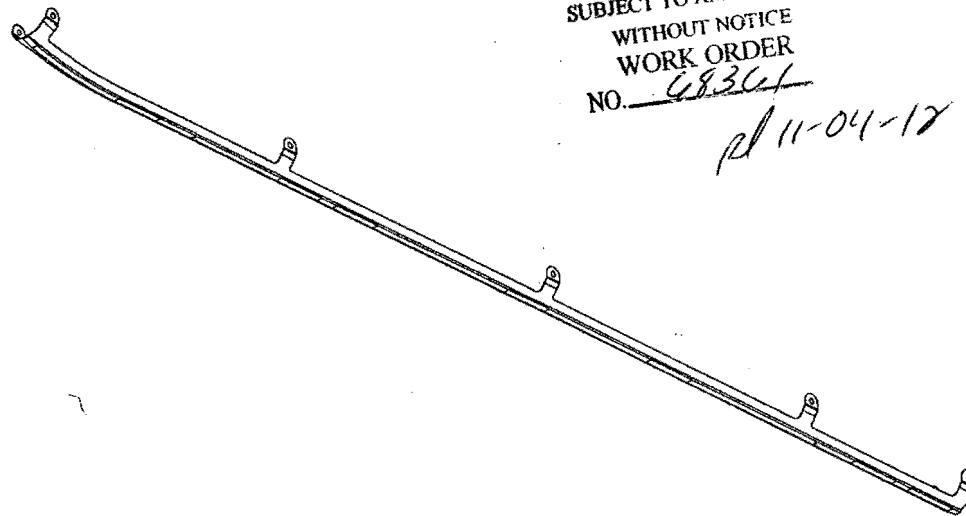
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 48361

11-04-12



D4154-041 WEARPLATE ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	PR 1422	SEALANT (SEE NOTE 11, SHT 2)

RELEASED
2010-09-15
UNDER REVIEW
11-04-09
Page 11-72

A		NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION			BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.			
DRAWN	SC	PORT HADLOCK, WA			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A		
MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 1 OF 3		
APPROVED	<i>[Signature]</i>	TITLE	SCALE		
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY		NTS	
DATE		10.07.22			
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

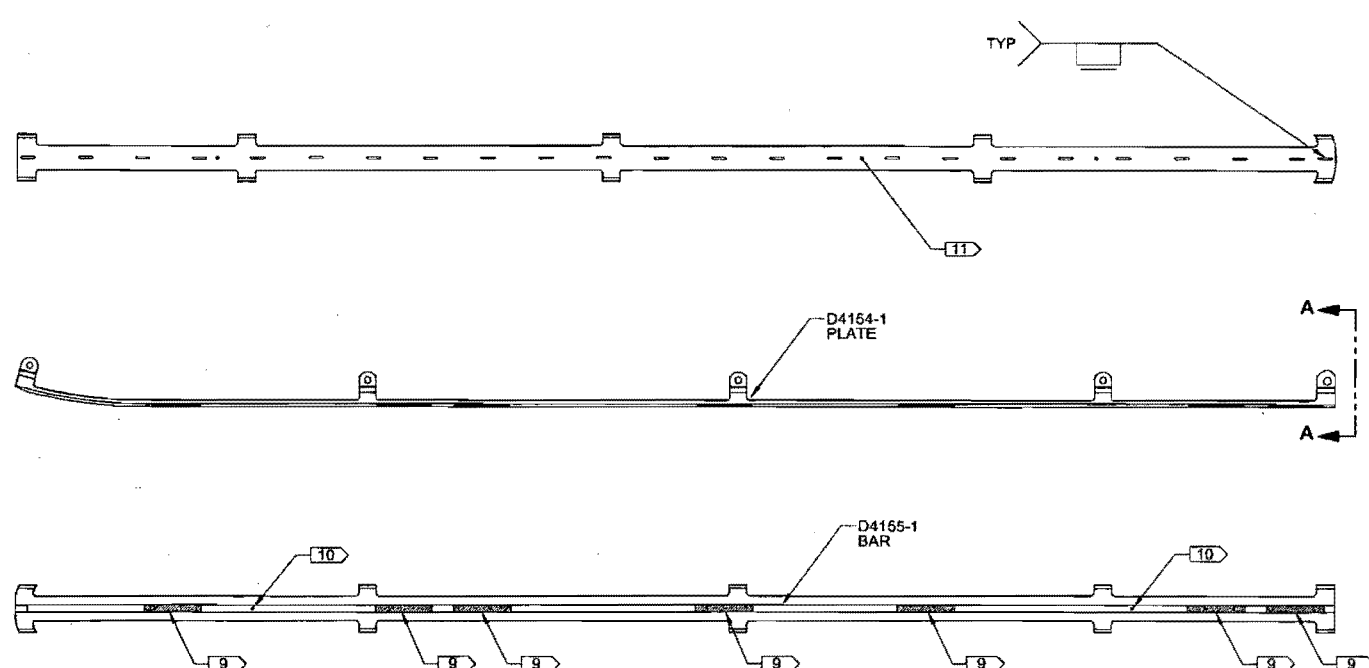
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NOTE: Date & initial all entries

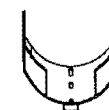
w/o 68361



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2010-09-15
UNDER REVIEW

11.04.09



SECTION A-A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 5.99 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL \varnothing 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) AFTER FINISH, COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF SIKAFLEX-241/-291 OR PROSEAL 890 OR PROSEAL 1422 OR MIL-S-8802 CLASS B SEALANT, 0.020-0.040 THICK.

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	UP	DRAWING NO.	REV. A
MFG. APPR.	BE	D4154	SHEET 2 OF 3
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	WEARPLATE ASSEMBLY	NTS
DATE	10.07.22	<small> COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

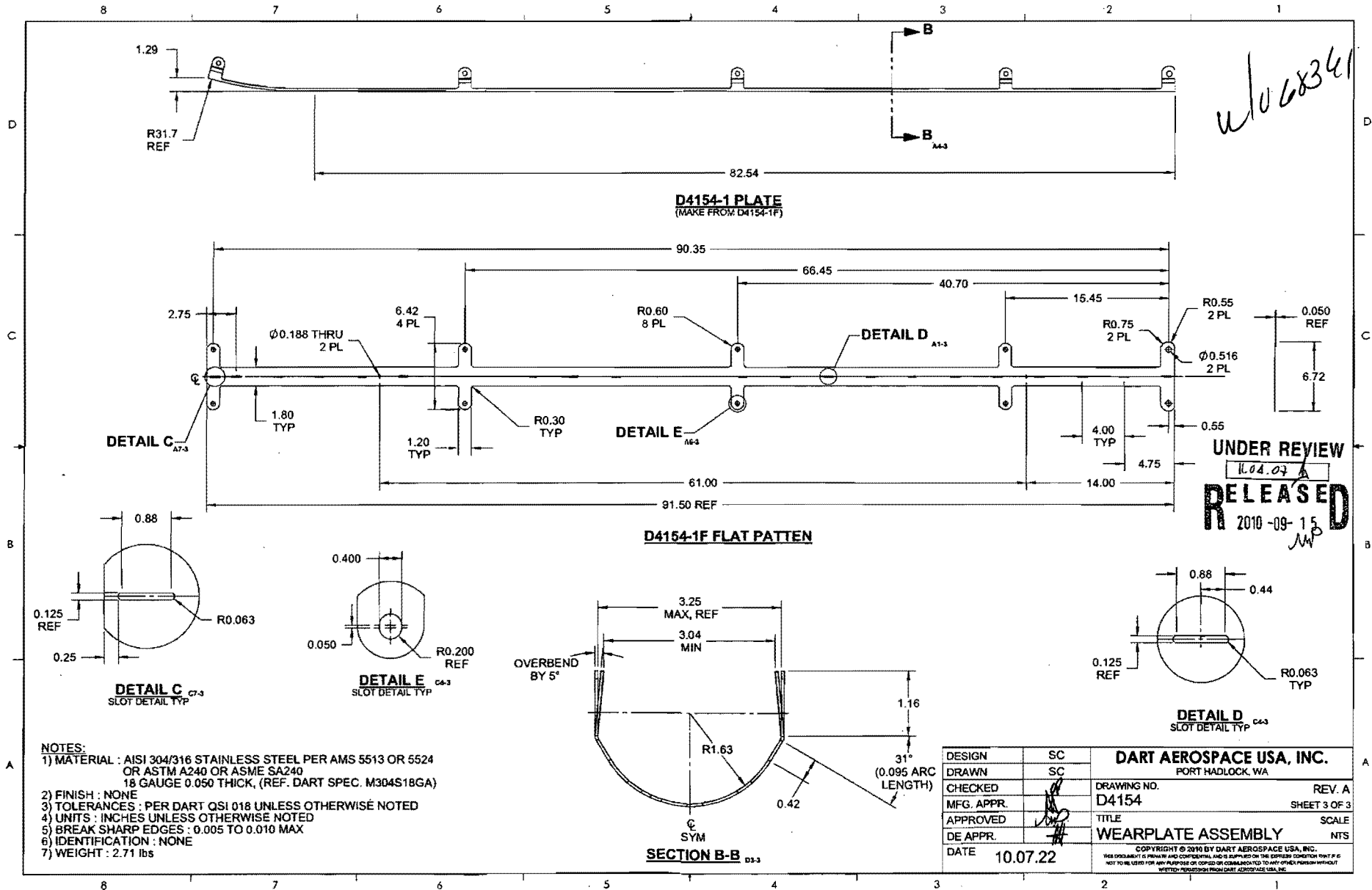
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

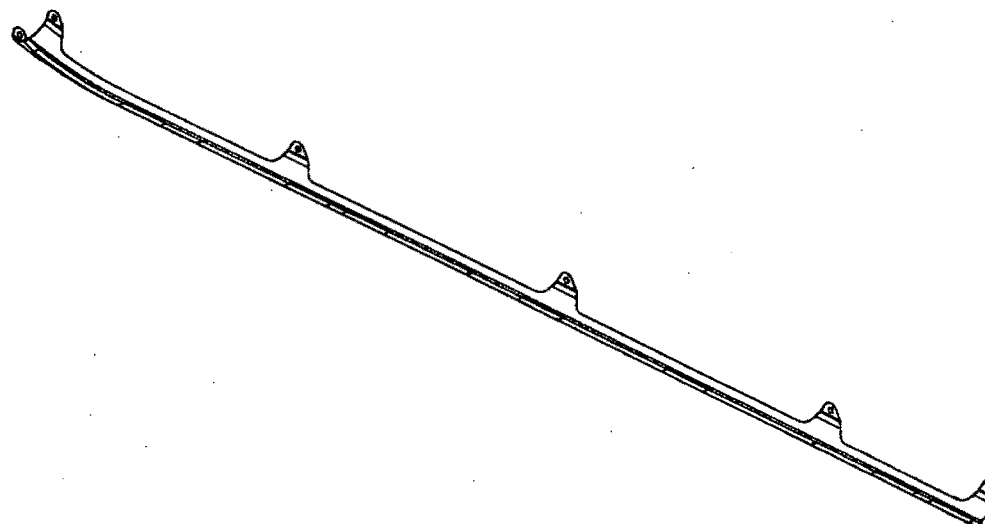
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

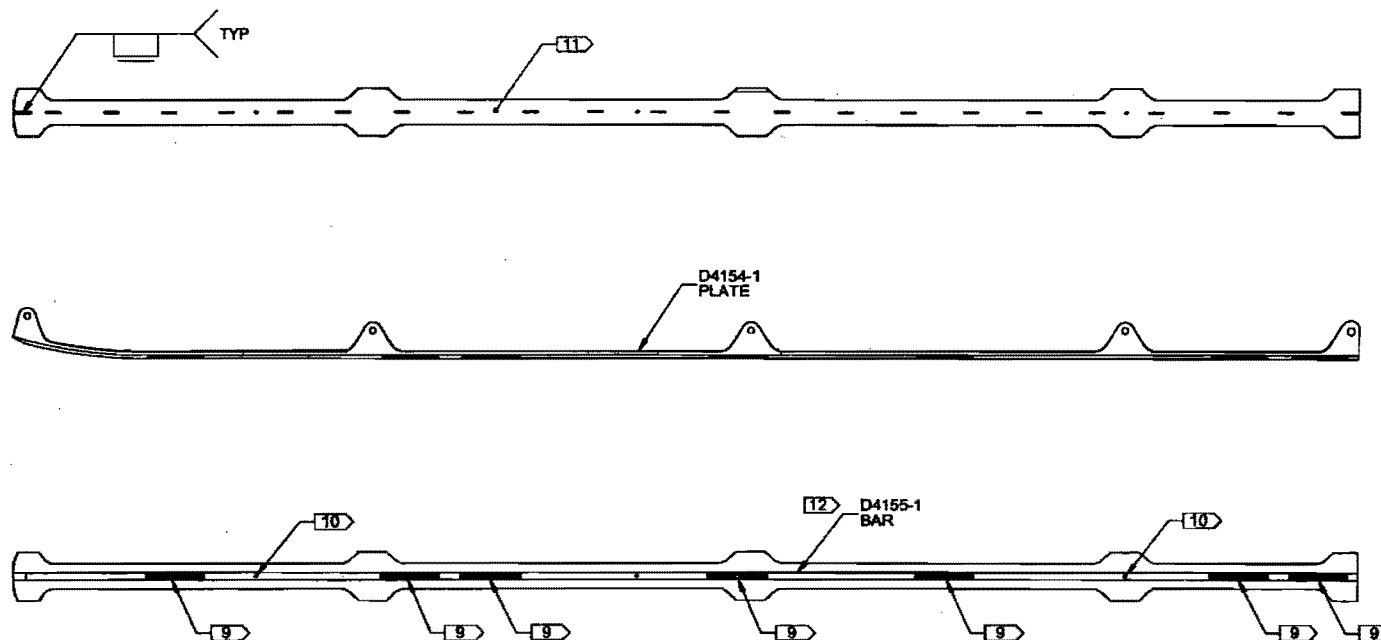
ITEM	QTY	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-12
JMP

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (AS-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC.	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	JMP	DRAWING NO.	REV. B
MFG. APPR.	JMP	D4154	SHEET 1 OF 3
APPROVED	JMP	TITLE	SCALE
DE APPR.	JMP	WEARPLATE ASSEMBLY	NTS
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D4154-041 WEARPLATE ASSEMBLY

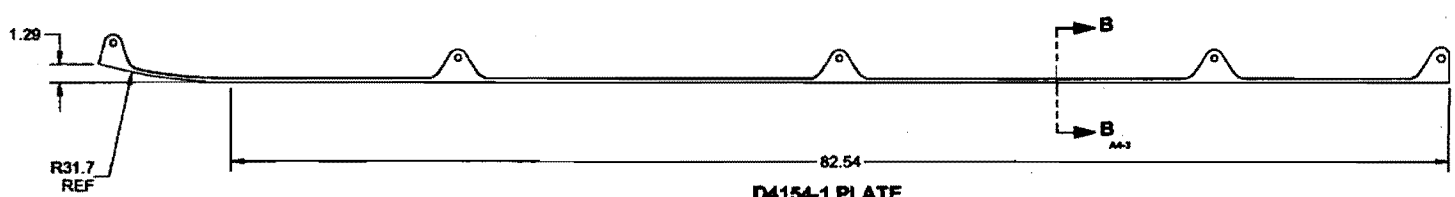
RELEASED
2011-04-13

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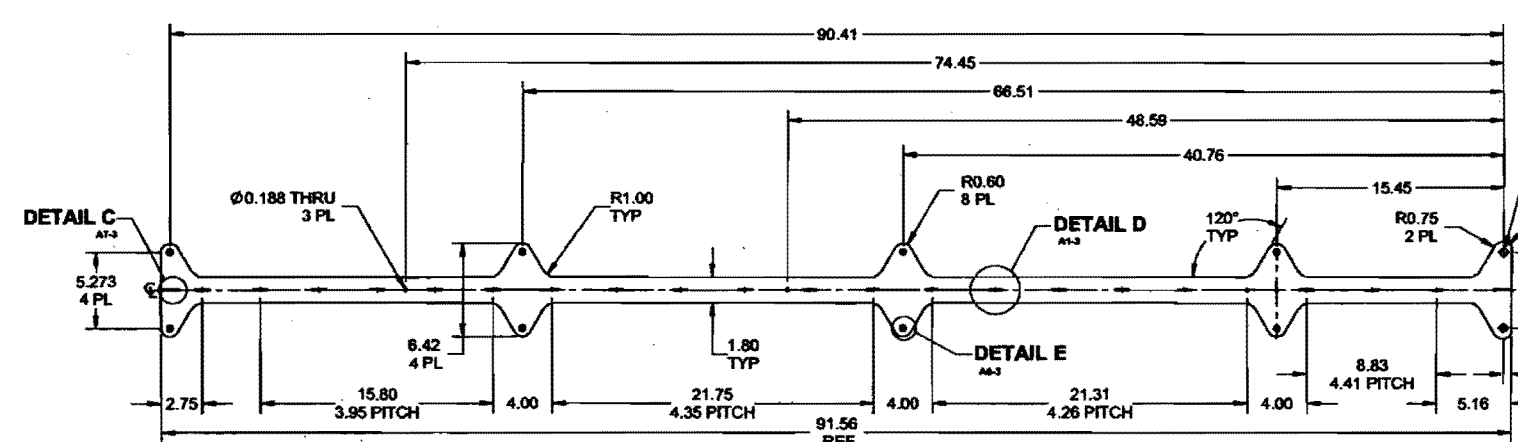
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL ϕ 0.188 HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
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MFG. APPR.	SC	D4154	SHEET 2 OF 3
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	WEARPLATE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

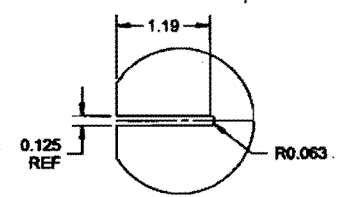


D4154-1 PLATE
(MAKE FROM D4154-1F)

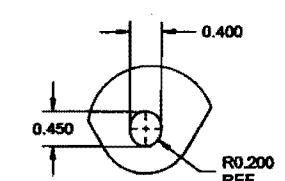


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2011-04-13

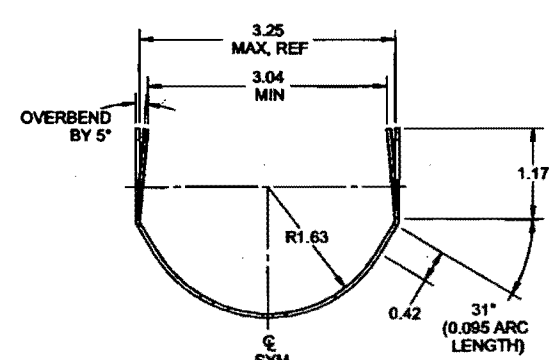
D4154-1F FLAT PATTERN



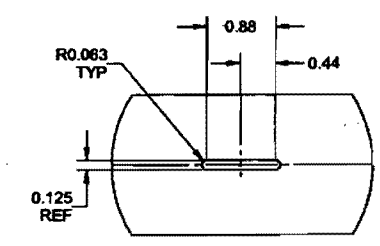
DETAIL C
END SLOT DETAIL, 2 PL



DETAIL E
SLOT DETAIL TYP



SECTION B-B



DETAIL D
SLOT DETAIL TYP

- NOTES:**
- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH : NONE
 - 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS : INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION : NONE
 - 7) WEIGHT : 2.95 lbs

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D4154	REV. B
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE WEARPLATE ASSEMBLY	SCALE NTS
DE APPR.		DATE 11.04.05	

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8 7 6 5 4 3 2 1

